

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009085**Date Inspected:** 16-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1745**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Du Zhiquan, Li Ming.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay10, East Tower, STRUTS.

SMAW welding of weld joint ED1-A6003-4-31, 29; located on Bay10, East Tower. Welder is identified as 076432, 037779; ZPMC Quality Control Inspector (QC) is identified as Du Zhiquan. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2113.

Bay10, South Tower, Plate.

FCAW welding of weld joint SSD1-SPSA3-56-4B; located on Bay10, South Tower. Welder is identified as 040345; ZPMC Quality Control Inspector (QC) is identified as Li Ming. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-F.

This QA Inspector carried out NDE on following:

Tower Assembly Yard, South Tower, Lift 1, Skin A, Buttering Area.

This QA inspector performs Random Visual Testing (VT), Magnetic Particle Testing (MT) of area previously tested and accepted by ZPMC Quality Control personnel, FOR GREEN TAG. This QA Inspector generated an MT report (TL-6028) for this date. The members are identified as Skin A, Buttering Area, Bottom side of the Tower.

This Inspection was not completed as ZPMC removed Manlift from the location & hence no access for

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Inspection. Area inspected by QA Inspector found in compliance.

Bay 11, West Tower, Lift 4, Skin A.

This QA inspector arrived to perform Inspection on the Location as per ZPMC Inspection Notification # 004223 & observed ZPMC doing grinding on the welds. ZPMC QC Li Xiu Yang agreed to complete ZPMC & AB/F inspection first & then renotify this Inspection to Caltrans QA.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 13482570045, who represents the Office of Structural Materials for your project.

Inspected By:	Juvekar,Amit	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
